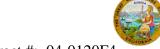
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-024671 Address: 333 Burma Road **Date Inspected:** 18-Jun-2011

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Mr. An Qing Xiang No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Orthotropic Box Girder (OBG)

Summary of Items Observed:

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Assembly bay#14.

The following Non Destructive Testing (NDT) Inspection was carried out as per the ZPMC submitted Notification No.09517.

Magnetic Particle Testing (MT)

This QA randomly witnessed and performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a MT report for this date. The members are identified as OBG weld Components. The weld joint identified as SEG3020*-002 has been performed from inside the segment. Total number of welds MT tested: (17). The weld designation inspected was as follows:

- 1. DP3168-001-098
- 2. DP3168-001-099
- 3. DP3168-001-101
- 4. DP3168-001-102

WELDING INSPECTION REPORT

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- 5. DP3168-001-106
- 6. DP3168-001-107
- 7. DP3168-001-112
- 8. DP3168-001-113
- 9. DP3184-001-001
- 10. DP3184-001-002
- 11. EP3029-001-014
- 12. EP3029-001-015
- 13. VP3019-001-007
- 14. VP3019-001-008
- 15. VP3019-001-009
- 16. SEG3020-257
- 17. SEG3020*-002

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3020S-119. Welder is identified as 066261. ZPMC QC is identified as Mr. An Qing Xiang. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-B-P-2112-FCM-1.

SMAW welding of weld joint identified as OBW14A-015. Welder is identified as 037997. ZPMC QC is identified as Mr. An Qing Xiang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS- B-P-2114-FCM-1.

SMAW welding of weld joint identified as SEG3020M-064. Welder is identified as 066734. ZPMC QC is identified as Mr. An Qing Xiang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS- B-P-2213-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3020R-186. Welder is identified as 067904. ZPMC QC is identified as Mr. An Qing Xiang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS- B-P-2213-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer